

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011386**Date Inspected:** 27-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liufa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 5

This QA inspector observed ZPMC qualified welding personnel identified as 066734 perform Flux Cored Arc Welding (FCAW) welding on Bike Path, weld joint identified as BK001-045-002 & 004. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 067275 perform FCAW welding on Bike Path, weld joint identified as BK001-042-001 & 003. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 204342 perform FCAW welding on Bike Path, weld joint identified as BK001-044-006 & BK001-046-006. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

This QA inspector observed ZPMC qualified welding personnel identified as 217185 perform FCAW welding on

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Bike Path, weld joint identified as BK001-047-006 & BK001-043-006. ZPMC QC is identified as Mr. Wang Liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

### Bay 7

This QA inspector observed ZPMC qualified welding personnel identified as 066695 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR1-002-001. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 068859 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR2-002-005. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 220063 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR3-001-007. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 053742 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR3-003-003. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 200676 perform FCAW Welding on Traveler Rail, weld joint identified as 22TR4-004-007. ZPMC QC is identified as Mr. Zhou Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U5-F.

### Bay 8

This QA inspector observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Welding (FCAW) welding on Floor Beam, weld joint identified as FB3057-055-028 & 062. ZPMC QC is identified as Mr. Zhang Qiao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 225082 perform Flux Cored Arc Welding (FCAW) welding on Floor Beam, weld joint identified as FB3057-053-002 & 034. ZPMC QC is identified as Mr. Zhang Qiao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Magnetic Particle Testing (MT) - Document No's: 004938

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This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. BK001-049-048, 041, 044, 045, 036, 037, 032, 033, 026, 027, 030, 031
2. BK001-049-018, 019, 022, 023, 012, 013, 016, 017, 042, 043, 034, 035
3. BK001-049-028, 029, 020, 021, 014, 015, 061~066
4. BK001-049-048, 049
5. BK001-050-048, 041, 044, 045, 036, 037, 032, 033, 026, 027, 030, 031
6. BK001-050-018, 019, 022, 023, 012, 013, 016, 017, 042, 043, 034, 035
7. BK001-050-028, 029, 020, 021, 014, 015, 061~066
8. BK001-050-048, 049
9. BK001-048-048, 041, 044, 045, 036, 037, 032, 033, 026, 027, 030, 031
10. BK001-048-018, 019, 022, 023, 012, 013, 016, 017, 042, 043, 034, 035
11. BK001-048-028, 029, 020, 021, 014, 015, 061~066
12. BK001-048-048, 049

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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